

Date: Wednesday, 4/25/2007 2:36:59 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI ACESS STEP LH
Job Number : 32058
Estimate Number : 11764
P.O. Number : *PN* Part Number : D206628022 *BL*
This Issue : 4/25/2007 S.O. No. : *N/A* Drawing Number : N/A
Prsht Rev. : NC Project Number : N/A
First Issue : *WNA* Type : LARGE FAB ASSY Drawing Revision : N/A
Previous Run : 31977 Material : *N/A*
Written By : Due Date : 5/4/2007 Qty: 1 Um: Each
Checked & Approved By : *H 07.04.25*
Comment : Est Rev.D as per ECN 766 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-022 CHG.002 *CL* *K 27.04.27* ①

2.0 32058A 206L /407 STEP ASSY, RH



Comment: Sub-Component SUB-COMPONENT

D2724-042 B *32058A*

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D27317 Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 D2731-7 Mounting Lug

to be shipped at a later date

5.0 D2856400 Abrasion Strip



Comment: Qty.: 1.1708 f(s)/Unit Total : 1.1708 f(s)

Pick :

Qty Part # Description Batch
2 D2856-400 6.9" Abrasion Strip

1330822 *7/5/12 SQ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:36:59 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH

Job Number: 32058

Part Number: D206628022

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3394043

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3394-043 LUG ASS,Y

to be shipped at a later date.

7.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-12A Bolt

M103962 ✓

8.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-13A Bolt

M103947 ✓

9.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-15A Bolt

M104072 ✓

10.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN960JD416 Washer

M102929 ✓

11.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21042L4 Nut (or MS21042-4)

M103914 ✓

7/5/12 SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 2 Date: 07/03/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:36:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH

Job Number: 32058

Part Number: D206628022

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



C207/05/18 (1)



Comment: INSPECT 100% KITS FOR COMPLETENESS

C207/05/18 (1)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-022

Location:

PPP Rev: F

C207/05/18 (1)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

C207/05/18

Job Completion



C207-05-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DEL FLEET BLUE 3024

Dart Aerospace Ltd.

Date: Wednesday, 4/25/2007 2:37:06 PM
User: Kim Johnston

D206.628-022

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L /407 STEP ASSY, RH
Job Number	: 32058A		
Estimate Number	: 11703		
P.O. Number	: N/A	Part Number	: D2724042
This Issue	: 4/25/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2724 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 31977A	Drawing Revision	: C
		Type	: LARGE FAB ASSY
		Material	: N/A
Written By	: <u> </u>	Due Date	: 5/4/2007
Checked & Approved By	: <u> </u>	Qty:	1 Um: Each
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion 330199

Check Material for any Dents or Defects

 07.04.26

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724

Deburr and bevel ends for welding

 07.04.26
 07.04.26

3.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description Batch

2 D2734 End Cap 329340 07.04.26

4.0

D34581

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3458-1 Plate 329354 07.04.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:37:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 32058A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

331074

PE. 07-04-26 1

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig
DT (One End Only)

A/R AL ROD Batch: M102756
M103317

Grind end cap welds flush

PE. 07-04-27 1

PE. 07-04-27 1

FF 07-04-30 1

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-05-01 ①

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/03 ①

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 07/05/07

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 07-05-08 1

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

PE. 07-05-09 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:37:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 32058A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig
DT
AVR AL ROD Batch: M102756

Grind end plate flush.

FL 07.05.09
FL 07.05.09

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/05/09 (1)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/09 (1)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

Prime *FL* *07/05/11 (1)*

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

→ *SPRAY PAINT DELFLEET BLUE AND CLEAR* *} IT 07-05-15* *M/070516 (1)*

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

07-05-17 (1) *POSITIVE RECALL*

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

M/03707 *FL* *07/05/17 (1)*

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-05-18 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector
070517	16.0	Awaiting for a signature for NCR reprint. Do not pass step 19.		070517	1	 070517	 070517

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070516	15	Primer is visible through the paint.	 051012	Scuff & repaint per Q51015. Apply even coats of blue & ensure full coverage	 070516	 070517	 051012	 070516

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:37:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 32058A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

32058

POSITIVE
RECALL

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PR 105/18

Job Completion



u 04/25/18

POSITIVE RECALL

EFFECTIVE 04/25/17 AUTH u

RELEASED ll DATE 04/25/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

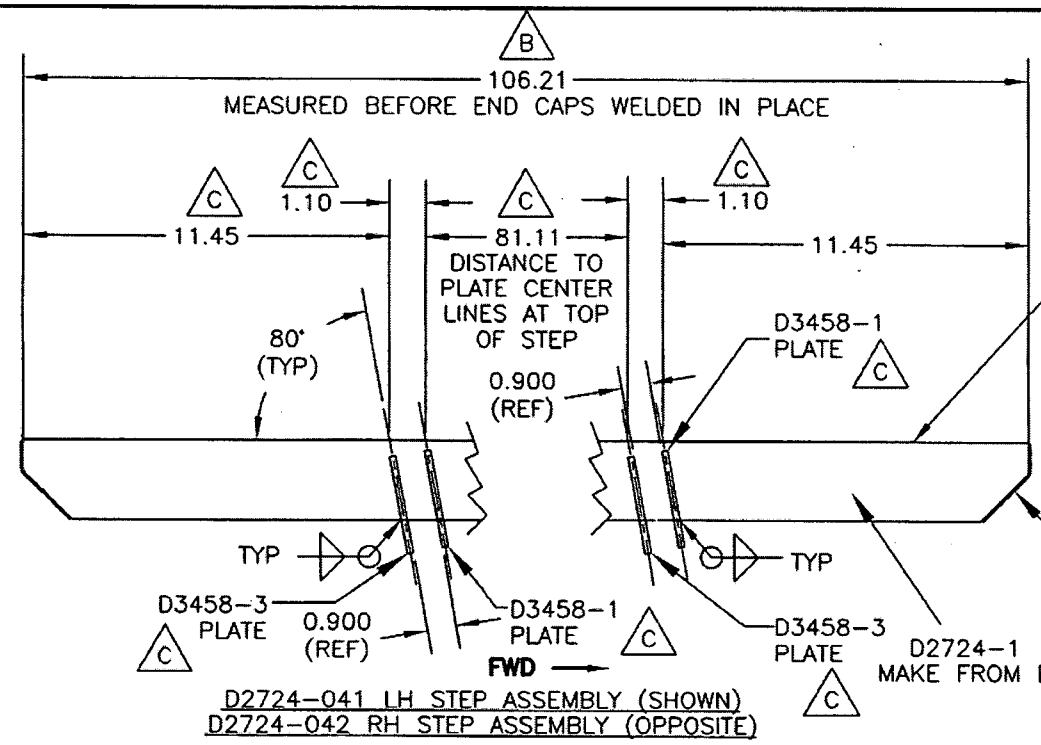
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



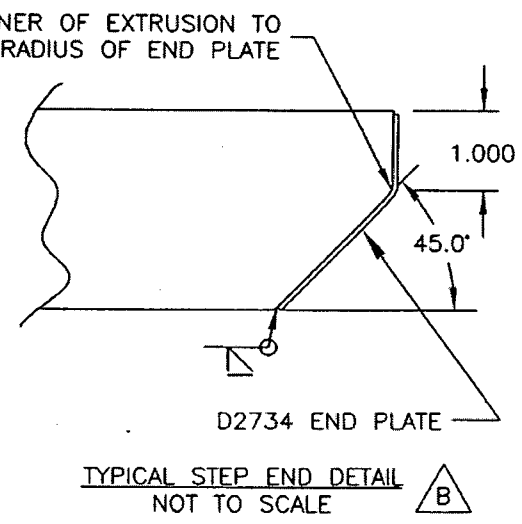
RELEASED
05.11.14

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19			
	A	97.12.04		206L/407 STEP ASSEMBLY
	B	98.10.19		NEW ISSUE
	C	05.09.19		RE-DESIGN, ADD D3458-1/-3
				UPDATED WELD DETAIL REVISED TOLERANCES
				SCALE
				NTS



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE



D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
520584

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